

Ship Friday

Work Order ID 56086

February 10, 2010 11:20:11 AM



Item ID: D212-725-1-205

Accept



Setup Start



Revision ID:

Stop



Item Name: Left Front Panel

Start Date: 2/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/17/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PA

Date: 10-2-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-725-1	PG1								
100		0.00							
	Waterjet								
FLOW CNC Waterjet	<p>Memo</p> <p>1-Cut as per Dwg D212-725-1-205</p> <p>Dwg Rev: <i>PG1</i></p> <p>Prog Rev: <i>Lun</i></p> <p>2-Deburr if necessary</p>	0.00							
									<i>10-2-11</i>
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
									<i>10-2-11</i>

PRELIMINARY ISSUE

Work Order ID 56086

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>Solo</i>		<i>(X)</i>			
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		<i>10/02/11</i>		<i>(X)</i>	<i>9</i>		
140 SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo PAINT FLAT BLACK AS PER DWG	0.00 0.00				<i>mt</i>		<i>10-02-16</i>	<i>(X)</i>

Work Order ID 56086

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Page 3

Item ID: D212-725-1-205

Accept



Setup Start



Revision ID:

Stop



Item Name: Left Front Panel

Start Date: 2/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/17/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC3- Inspect Part Finish

0.00



S Q214

QC

Memo

0.00

Quality Control

[Signature]

8/10/2/16



160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Sent to Harvey
at Eagle
10/02/16 under
Pos. Recall *[Signature]*

10-2-16 *[Signature]*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 10-2-16

POSITIVE RECALL

EFFECTIVE 10/2/10 AUTH *[Signature]*

RELEASED _____ DATE _____

Picklist Print

February 10, 2010 11:20:16 AM

Page 1

Work Order ID: 56086



Parent Item: D212-725-1-205



Parent Item Name: Left Front Panel

Start Date: 2/10/10

Required Date: 2/17/10

Comments: IPP RevA: new issue DD 10.02.10 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	226.2623	2.4411			



6061-T6 .125 Sheet



2010-2-11

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

226.2623

110062

1.85

111642

19.592

112476

32

112567

18.7403

113424

58.08

113608

96

113424

①

DART AEROSPACE LTD		Work Order: 56086
Description: LEFT FRONT PANEL		Part Number: D212-725-1-205
Inspection Dwg: D212-725-1-205	Rev: PLS Lim PC71	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.965	+ .012 - .001	1.964	✓			
Ø 2.265	+ .012 - .001	2.264	✓			
Ø 2.828	+ .012 - .001	2.828	✓			
Ø 3.165	+ .012 - .001	3.165	✓			
1.88	+/- .030	1.88	✓			
5.13	+/- .030	5.13	✓			
6.39	+/- .030	6.387	✓			
8.33	+/- .030	8.332	✓			
12.15	+/- .030	12.15	✓			
12.85	+/- .030	12.875	✓			
13.15	+/- .030	13.13	✓			
13.85	+/- .030	13.85	✓			
2.50	+/- .030	2.510	✓			
4.75	+/- .030	4.755	✓			
6.50	+/- .030	6.502	✓			
9.74	+/- .030	9.742	✓			
17.25	+/- .030	17.25	✓			
19.76	+/- .030	19.76	✓			
21.69	+/- .030	21.69	✓			
4.00	+/- .030	4.000	✓			
10.13	+/- .030	10.133	✓			
13.00	+/- .030	13.00	✓			
15.40	+/- .030	15.380	✓			

Measured by: RB	Audited by: J	Prototype Approval:	N/A
Date: 10-2-11	Date: 10/2/11	Date:	N/A

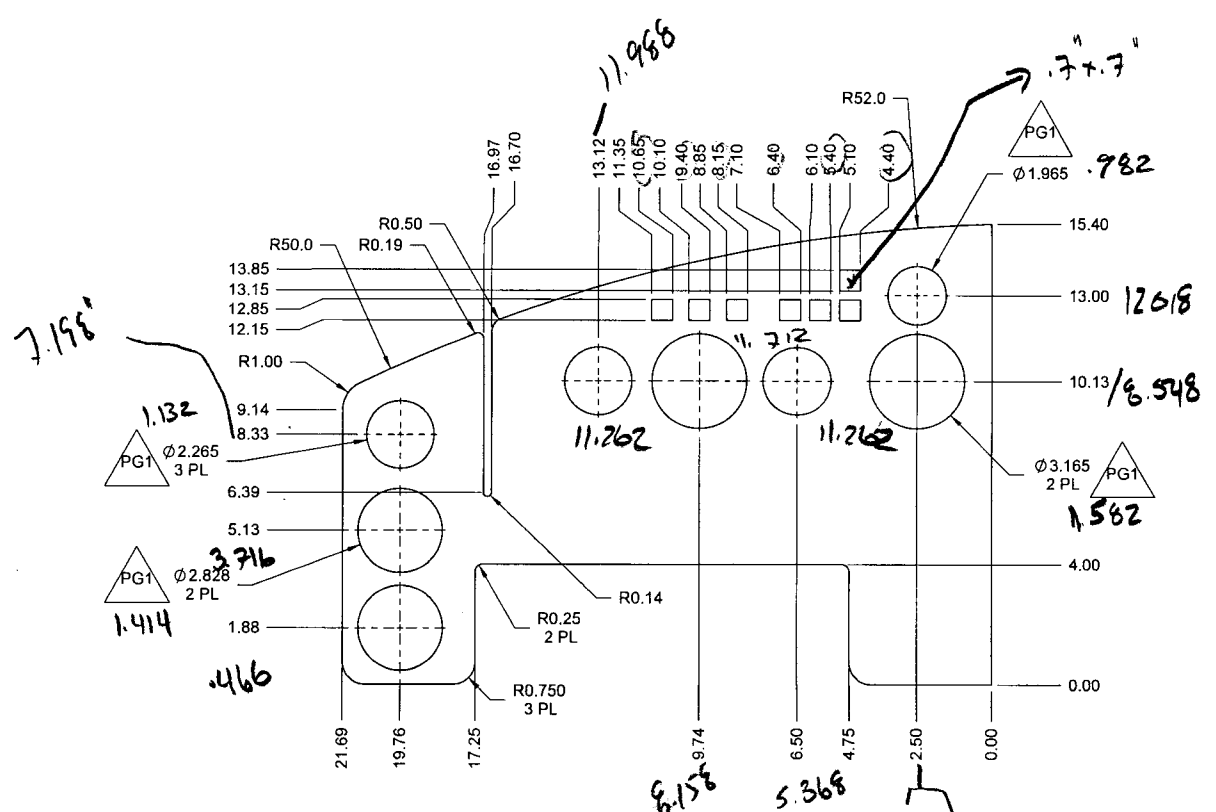
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

002-725-1-205

☒ **First Article** ☐ **Prototype**

Measured by:	HB	Audited by:	8	Prototype Approval:	N/A
Date:	10-2-11	Date:	10/2/11	Date:	N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56084
BY 10-2-10

PRELIMINARY ISSUE
10.01.27

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M8061T6S.125
OR 2024-T3 ALUMINUM SHEET
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PAINT FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50
PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.35 lbs

**D212-725-1-205 LEFT FRONT PANEL
GENERATION 2 PANEL**

PG1	REFORMAT DRAWING TO CURRENT STANDARDS: Ø2.828 WAS Ø2.812 (ZN B7-1); Ø2.265 WAS Ø2.250 (ZN C7-1); Ø1.965 WAS Ø1.950 (ZN D3-1); Ø3.165 WAS Ø3.150 (ZN C3-1)	RF	10.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PG1
MFG. APPR.		D212-725-1-205	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	10.01.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	